

## Work Order ID 121997

July-09-14 10:17:53 AM

\*121997\*

Page 1

Item ID: D4785-117

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Rib Assembly

Start Date: 7/09/14 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 7/09/14 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: ML5 Date: 14-07-09

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4785	B
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100

0.00

\*100\*

Large Fab

Memo

0.00

Large Fab

1- Pick D4306-1 and drill and chamfer hole as per dwg D4785 using DT9922

(2) CC 14-7-9

105

QC6- Inspect dimensions to drawing

0.00

\*105\*

QC

Memo

0.00

Quality Control

2+ 14-7-9

107

Weld per dwg A/R S.S. rod Batch: W1A

0.00

\*107\*

Large Fab

Memo

0.00

Large Fab

1- weld bushing as per dwg D4785  
2- grind welds flush

(2) CC 14-7-9

Work Order ID 121997

July-09-14 10:17:53 AM

\*121997\*

Page 2

Item ID: D4785-117

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Rib Assembly

Start Date: 7/09/14

Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 7/09/14

Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110

QC5- Inspect part completeness to step on W/O

0.00

\*110\*

QC

Memo

0.00

Quality Control

2x

DAS  
43  
9-89

14-7-10

120

QC10- Inspect visual per QSI004- ground welds

0.00

\*120\*

QC

Memo

0.00

Quality Control

2x

DAS  
43  
9-89

14-7-10

130

Identify as per dwg & Stock Location: *W/A*

0.00

\*130\*

Packaging

Memo

0.00

Packaging

2x CC 14-7-10

Work Order ID 121997

July-09-14 10:17:53 AM

\*121997\*

Page 3

Item ID: D4785-117

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Rib Assembly

Start Date: 7/09/14 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 7/09/14 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

140

QC21- Final Inspection - Work Order Release

0.00

\*140\*

QC

Memo

0.00

Quality Control

MLJ 14-07-14  
MLJ 14-07-11

# Picklist Print

July-09-14 10:17:56 AM

Page 1

Work Order ID: 121997

**\*121997\***

Parent Item: D4785-117

**\*D4785-117\***

Parent Item Name: Rib Assembly

Start Date: 7/09/14

Required Date: 7/09/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.06.21 DWG REV.B DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4021-9

Manufactured No

Each 331.0000

2

**\*D4021-9\***

\*\*

CC 14-7-9

Bushing

Location

Loc Qty

Loc Code

WA004

331

B117495 → (4x)

107634

22

116010

92

116663

64

117495

97

120334

40

121049

16

D4306-1

Manufactured No

Each 8.0000

1

**\*D4306-1\***

\*\*

CC 14-7-9

Rib

Location

Loc Qty

Loc Code

WA004

8

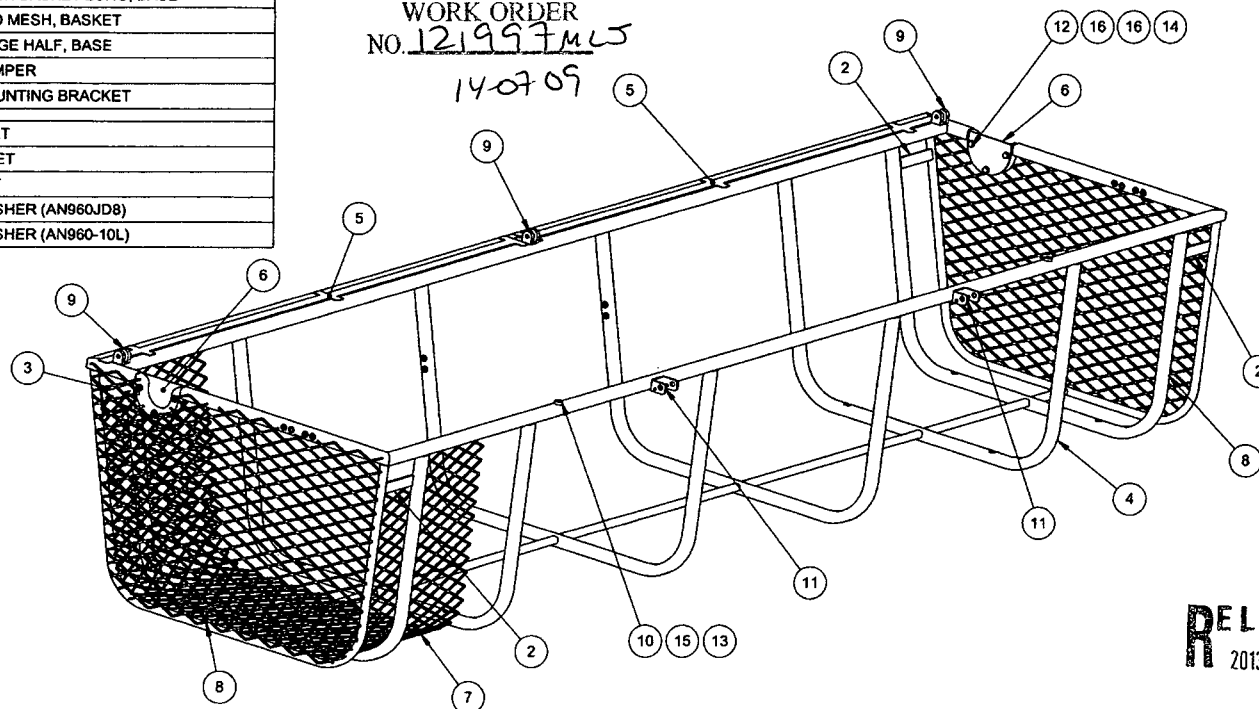
121313

8

(2x)

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4785-041	LONG BASKET BASE ASSY, LH/RH
2	3	D4793-1	HANDLE PLATE
3	1	D4793-3	WIDE HANDLE PLATE
4	1	D4785-101	TUBULAR ASSEMBLY, LH/RH
5	2	D4672-1	BLANKING PLATE
6	2	D4021-5	BLANKING PLATE
7	1	D4020-1	MESH BASKET LONG, BASE
8	2	D4020-11	END MESH, BASKET
9	3	D4016-1	HINGE HALF, BASE
10	2	D2931	BUMPER
11	2	D2581	MOUNTING BRACKET
12	6	AN3-10A	BOLT
13	2	MS20600AD4W3	RIVET
14	6	MS21042L3	NUT
15	2	NAS1149DN832J	WASHER (AN960JD8)
16	12	NAS1149F0332P	WASHER (AN960-10L)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 121997ML5  
14-07-09



**D4785-041 LONG BASKET BASE ASSY, LH/RH**

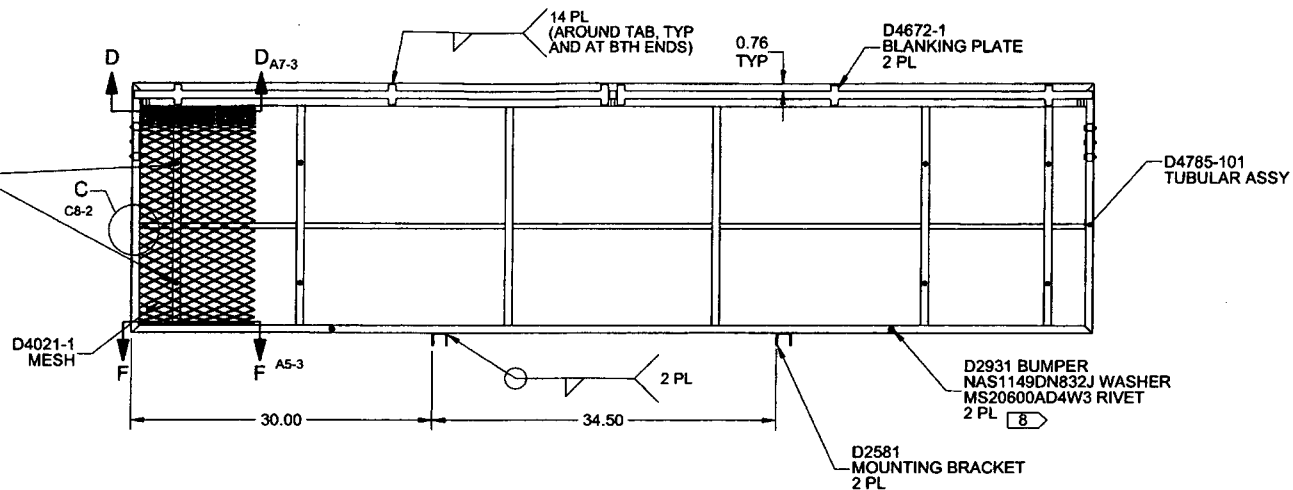
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 50.42 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

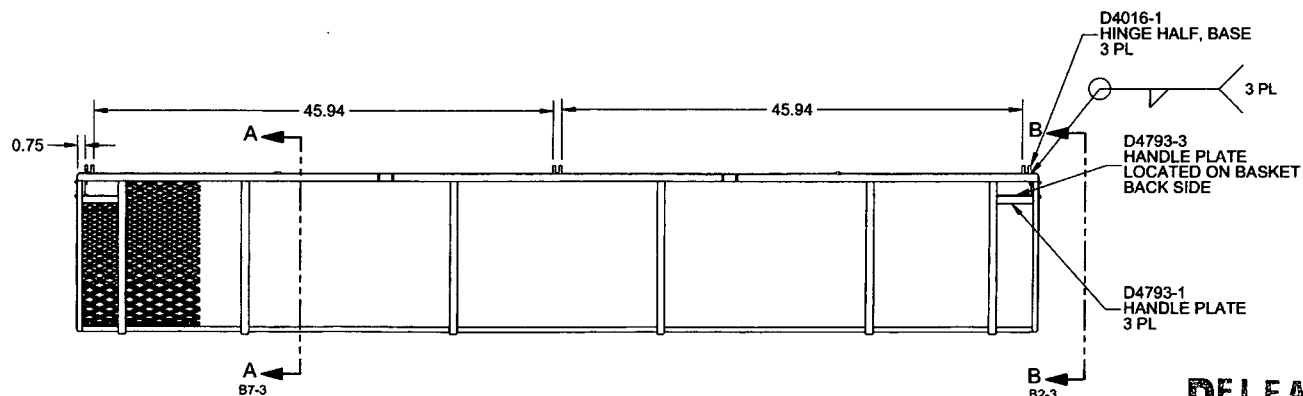
**RELEASED**  
2013-06-20  
MD

B	REPLACE D3916-5 WITH D4785-117 (ZN B5-4, B4-4, B5-7); REVISE D4785-5 DIMENSION (ZN B5-5)	RF	13.06.11
A	NEW ISSUE	RF	13.05.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	DS	D4785	SHEET 1 OF 7
APPROVED	TS	TITLE	SCALE
DE APPR.	TS	LONG BASKET BASE ASSY	NTS
DATE	13.06.11	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

TRIM MESH LOCALLY  
Ø0.50 - Ø0.60  
TO CLEAR BUSHINGS  
TYP



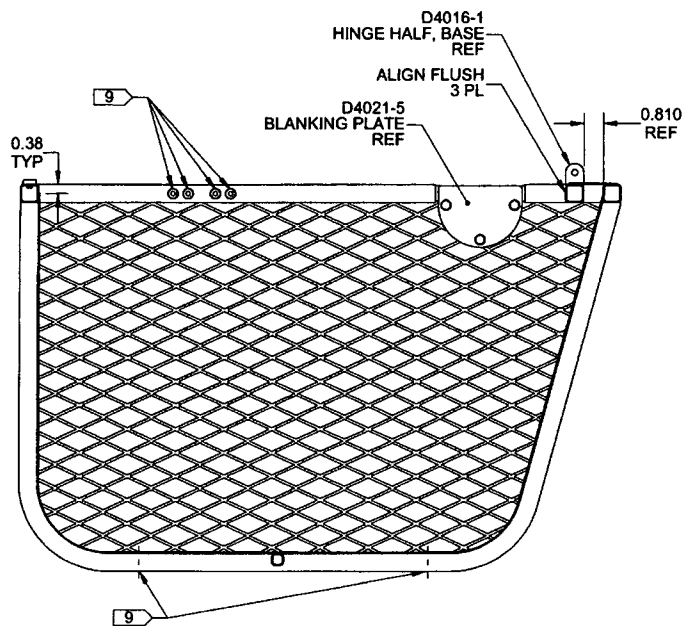
**DETAIL C** D7-2



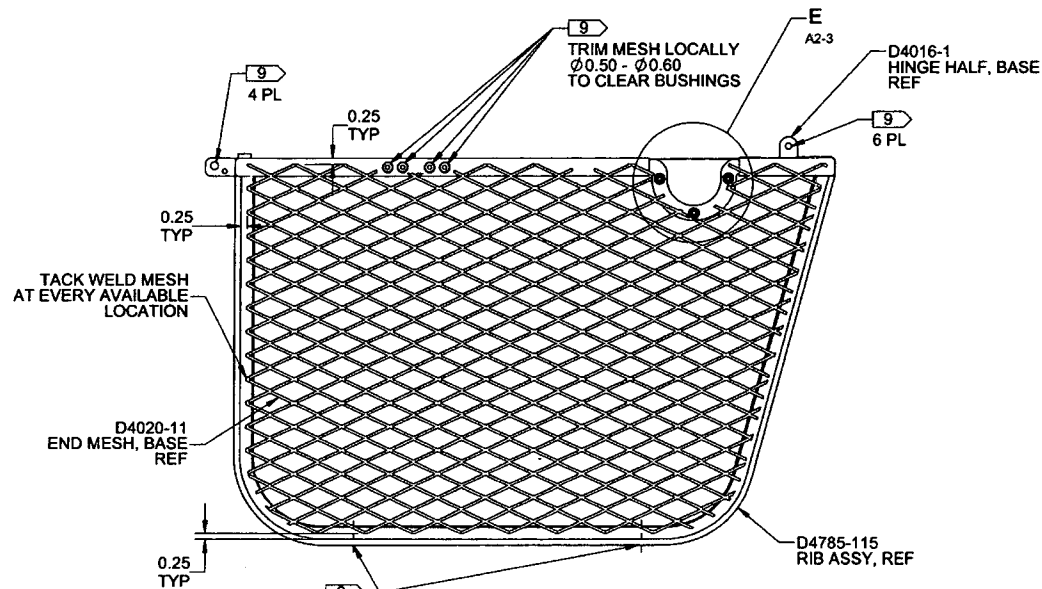
**D4785-041 LONG BASKET BASE ASSY, LH/RH**  
(MESH SHOWN LOCALLY FOR CLARITY)

**RELEASED**  
2013-06-20

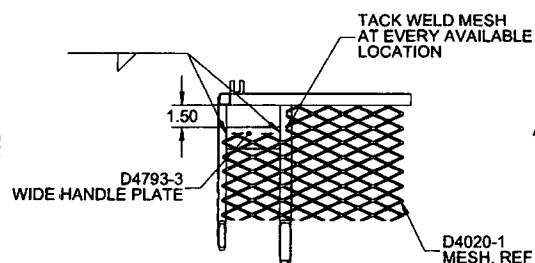
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>SC</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>NS</i>	<b>D4785</b>	SHEET 2 OF 7
APPROVED	<i>NS</i>	TITLE	SCALE
DE APPR.	<i>NS</i>	<b>LONG BASKET BASE ASSY</b>	NTS
DATE	13.06.11	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



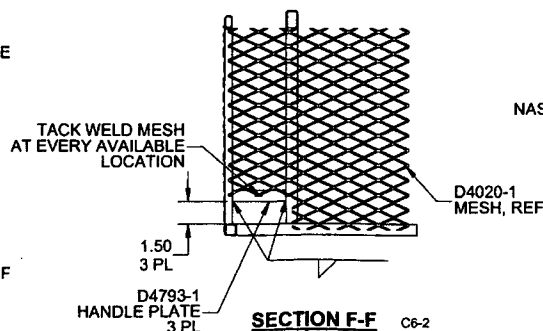
**SECTION A-A** 87-2



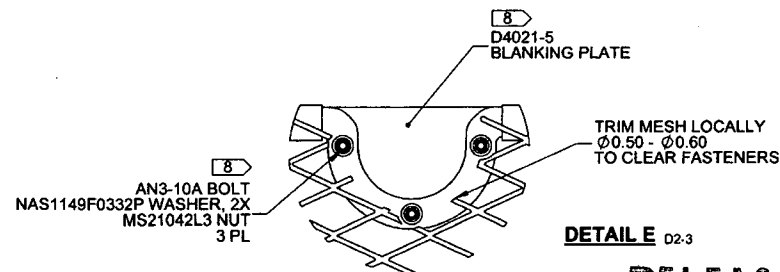
**SECTION VIEW B-B** A2-2



**SECTION D-D** D6-2



**SECTION F-F** C6-2  
TYPICAL ON 3 PL

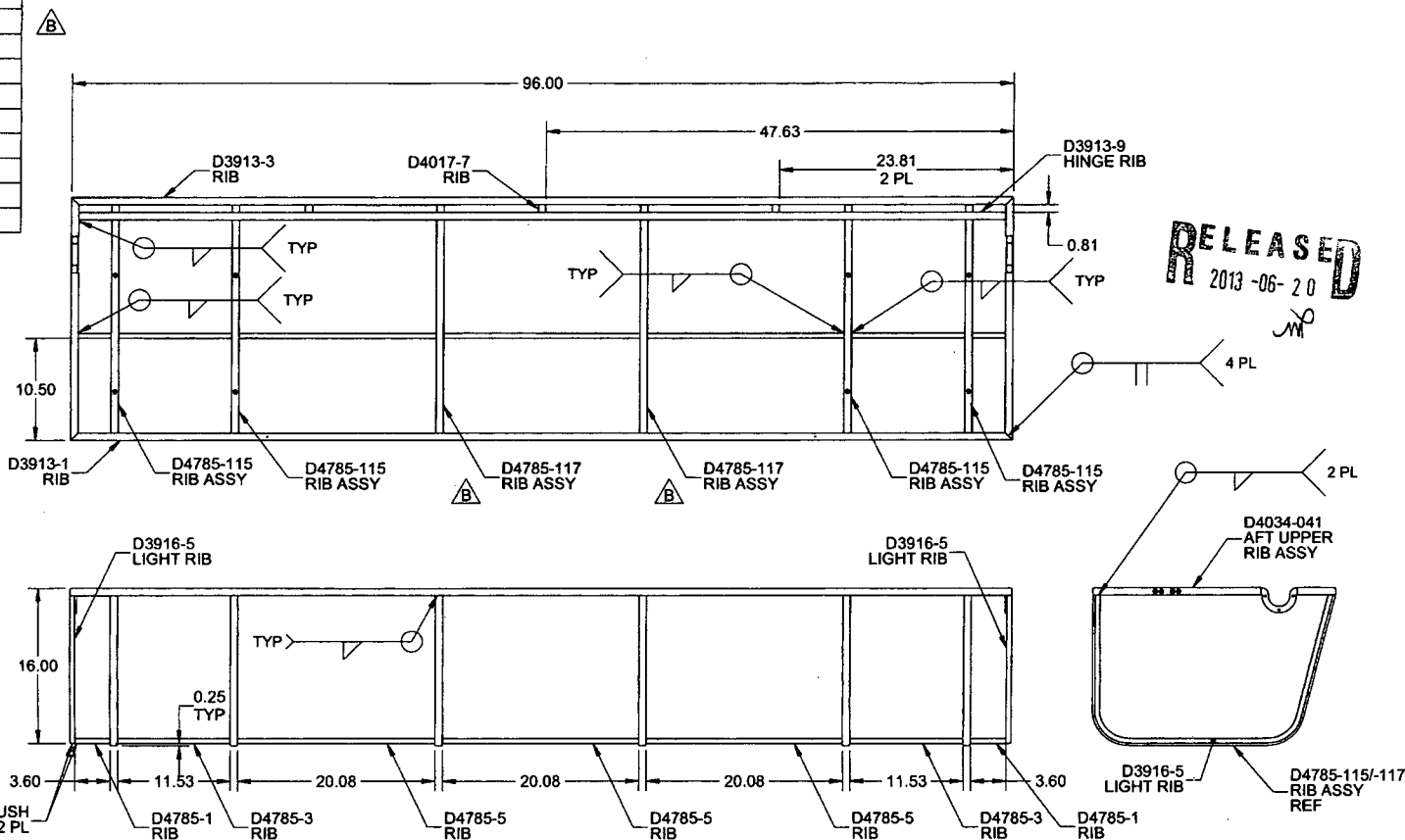


**DETAIL E** D2-3

**RELEASED**  
2013-06-20

DESIGN	RF	717	
DRAWN	RF	<b>DART AEROSPACE LTD</b>	
		HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. B
MFG. APPR.	N	D4785	SHEET 3 OF 7
APPROVED	#	TITLE	SCALE
DE APPR.	#	LONG BASKET BASE ASSY	NTS
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ITEM NO.	QTY. -101	PART NUMBER	DESCRIPTION
1	X	D4785-101	TUBULAR ASSEMBLY
2	2	D4785-1	RIB
3	3	D4785-5	RIB
4	4	D4785-115	RIB ASSEMBLY
5	2	D4785-117	RIB ASSEMBLY
6	2	D4785-3	RIB
7	3	D4017-7	RIB
8	1	D4034-041	AFT UPPER RIB ASSY
9	1	D4034-043	FWD UPPER RIB ASSY
10	2	D3916-5	RIB, LIGHT
11	1	D3913-1	RIB
12	1	D3913-3	RIB
13	1	D3913-9	HINGE RIB



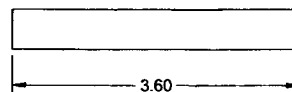
RELEASED  
2013-06-20

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 28.65 lbs
  - 8) WELD PER DART QSI 004

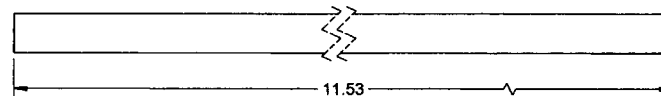
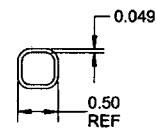
**D4785-101 TUBULAR ASSEMBLY, LH/RH**

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PC	DRAWING NO.	REV. B
MFG. APPR.	IS	<b>D4785</b>	SHEET 4 OF 7
APPROVED	SH	TITLE	SCALE
DE APPR.	SH	<b>LONG BASKET BASE ASSY</b>	NTS
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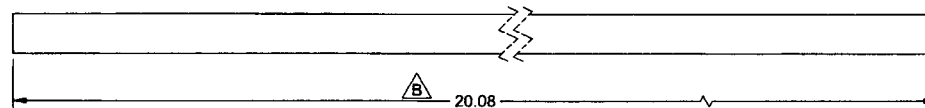
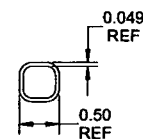




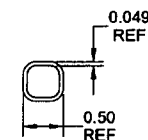
**D4785-1 RIB**



**D4785-3 RIB**



**D4785-5 RIB**



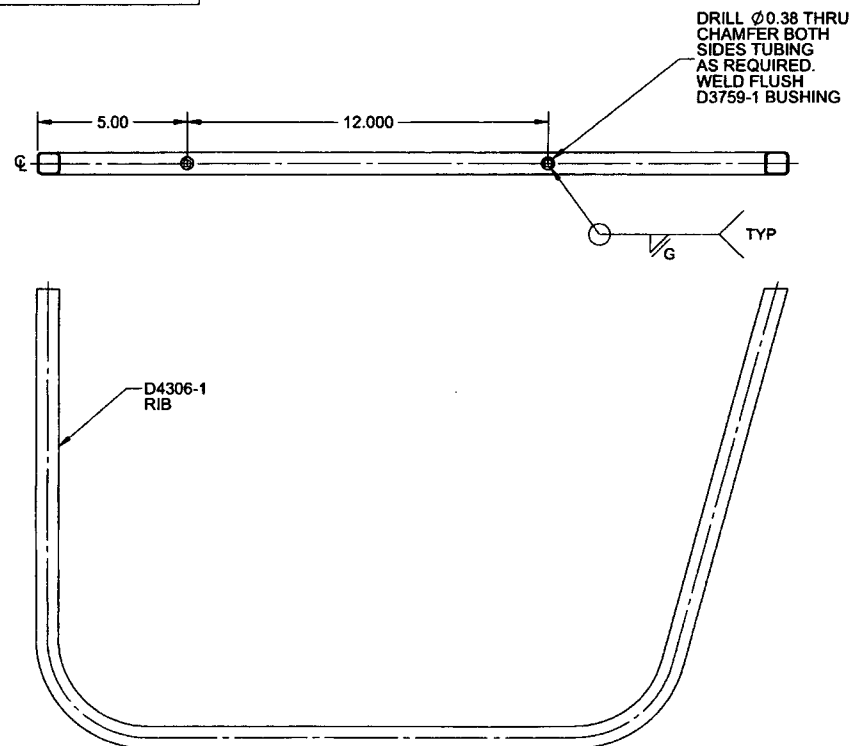
**NOTES:**

- 1) MATERIAL: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 x 0.50 x 0.049 WALL  
PER ASTM A554 OR ASTM A269 MILL FINISH  
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

**RELEASED**  
2013-06-20  
*mt*

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>PC</i>	DRAWING NO. <b>D4785</b>	REV. B
MFG. APPR.	<i>JS</i>	SHEET 5 OF 7	
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	<b>LONG BASKET BASE ASSY</b>	NTS
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ITEM NO.	QTY. -115	PART NUMBER	DESCRIPTION
1	X	D4785-115	RIB ASSEMBLY
2	1	D4306-1	RIB
3	2	D3759-1	BUSHING



**D4785-115 RIB ASSEMBLY**  
MAKE FROM D4306-1 RIB

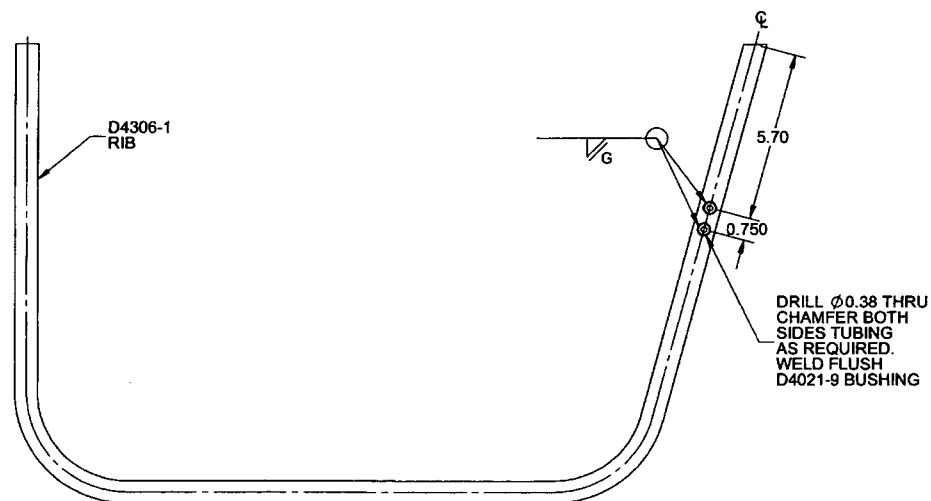
**RELEASED**  
2013-06-20  
JMD

**NOTES:**

- 1) MATERIAL: D4306-1 RIB
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.80 lbs
- 8) WELD PER DART QSI 004

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PC	DRAWING NO.	REV. B
MFG. APPR.	JS	D4785	SHEET 6 OF 7
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	LONG BASKET BASE ASSY	NTS
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ITEM NO.	QTY. -117	PART NUMBER	DESCRIPTION
1	X	D4785-117	RIB ASSEMBLY
2	1	D4306-1	RIB
3	2	D4021-9	BUSHING



**D4785-117 RIB ASSEMBLY**   
MAKE FROM D4306-1 RIB

**NOTES:**

- 1) MATERIAL: D4306-1 RIB
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.81 lbs
- 8) WELD PER DART QSI 004

**RELEASE**  
2013-06-20

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO. <b>D4785</b>	REV. B
MFG. APPR.		TITLE <b>LONG BASKET BASE ASSY</b>	SHEET 7 OF 7
APPROVED		SCALE	NTS
DE APPR.		COPYRIGHT © 2013 BY DART AEROSPACE LTD	
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